

Date: Wednesday, 26/11/2008 12:46:00 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT		
Job Number	: 43749		Part Number	: D2565307		
Estimate Number	: 10981		Drawing Number	: D2565 REV E		
P.O. Number	:		Project Number	: N/A		
This Issue	: 26/11/2008	S.O. No. :	Drawing Revision	: E		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 10/12/2008	Qty:	6
Previous Run	: 40682		Um:	Each		
Written By	:					
Checked & Approved By	: JWD 08.11.26					
Comment	: Est:A 02.06.10 New Issue NG					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W 12.9234
Comment: Qty.: 1.8462 f(s)/Unit Total : 11.0773 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049)		Batch No: M11027 ( 83 08/01/07 ) 7
2.0	BRAKE NC	NC BRAKE 83 08/01/07 7
Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 83 08/01/07 7
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr		M.F. 09-01-08 09/01/08 7X
4.0	QC5	INSPECT WORK TO CURRENT STEP 83 09/01/08 7X
Comment: INSPECT WORK TO CURRENT STEP		
5.0	POWDER COATING	POWDER COATING M109996 83 09/01/09 7X
Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3		
START TIME: <u>10:15</u>		
OVEN TEMPERATURE: <u>400°</u>		
FINISH TIME: <u>10:45</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 26/11/2008 12:46:00 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 43749

Part Number: D2565307

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*JS*



Comment: INSPECT POWDER COAT

*09-09-01*

*(7)*

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 253.*

*SS*

*09/01/09 (7)*

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/01/12 (7)*

Job Completion



*MF 09-01-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

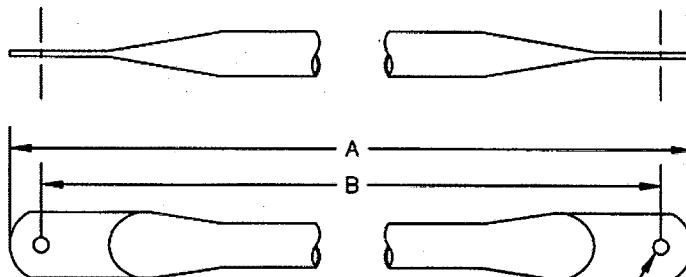
NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2565	SHEET 1 OF 1
DATE	TITLE		SCALE
04.05.05	STRUT		1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

**RELEASED**

04.05.05



DIA 0.257 TO BE PUNCHED  
 "C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 4374

**GENERAL NOTES**

1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL

(REF. DART SPEC. M304TR0.750W0.049)

ENSURE SEAMLESS TUBE IS USED

2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

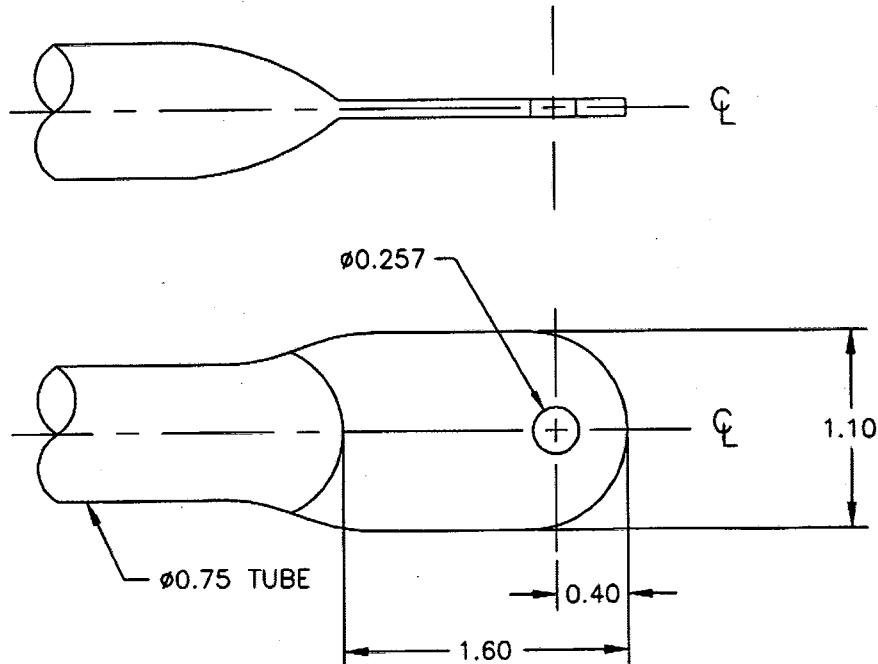
4) ALL DIMENSIONS ARE IN INCHES

**DART**

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DNY	APPROVED J	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

**RELEASED**  
4/05/05 KE

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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WITHOUT NOTICE  
WORK ORDER  
NO. 433449